

Date: Wednesday, 12/20/2006 3:31:32 PM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SMALL ENGINE MOUNT
 Job Number : 30060
 Estimate Number : 12611
 P.O. Number : N/A Part Number : D2127251110
 This Issue : 12/20/2006 S.O. No. : N/A Drawing Number : D212-725-1 REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : A
 Previous Run : N/A Material : N/A
 Written By : Due Date : 12/27/2006 Qty: 2 Um: Each
 Checked & Approved By :
 Comment : Est Rev: A New Issue 06-12-19 JLM

Additional Product

Job Number:

Seq. #: Machine Or Operation: Description :

1.0 M4140NB1500X15000 AISI 4140 Steel Bar

Comment: Qty.: 0.2972 f(s)/Unit Total : 0.5943 f(s)

AISI 4140 Steel Bar 1.500" X 1.500"

Batch: M102949 J.F. 06/12/21 (2)

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1

Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA657 and Dwg D212-725-1 J.F. 06/12/21 (2)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE J.F. 06/12/21 (2)

4.0 QC8 SECOND CHECK

Comment: SECOND CHECK SA 06-12-21 (2)

5.0 PACKAGING 1 PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock

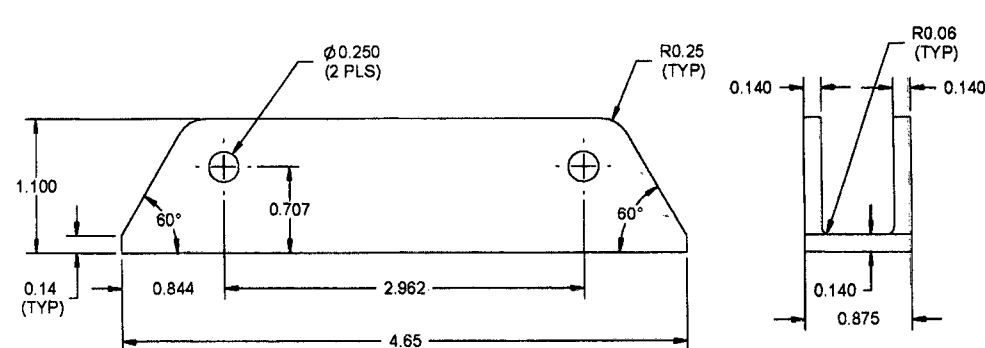
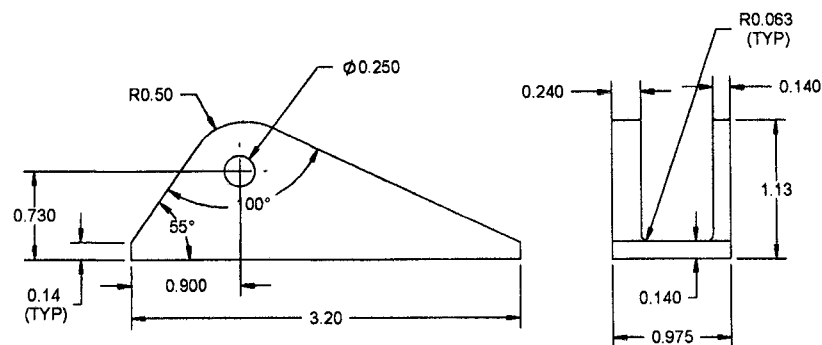
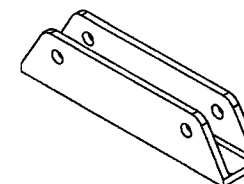
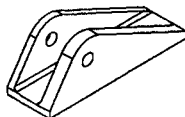
Location: N/A u 06/12-21

6.0 QC21 FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE u 06-12-21 (2)

Job Completion

8 7 6 5 4 3 2 1



D212-725-1-109 SMALL ENGINE MOUNT
D212-725-1-110 OPPOSITE

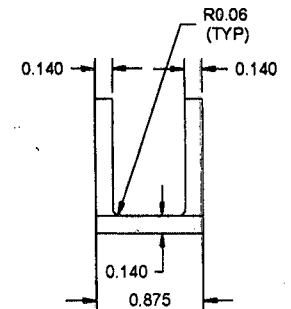
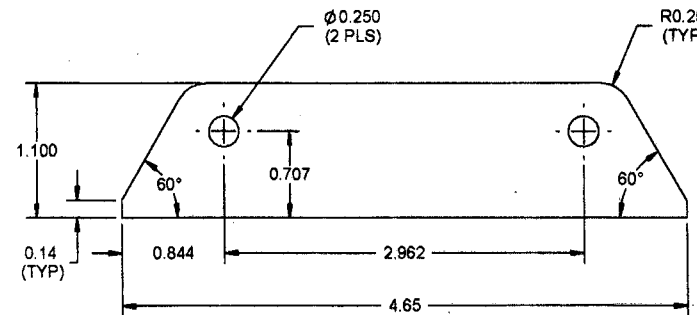
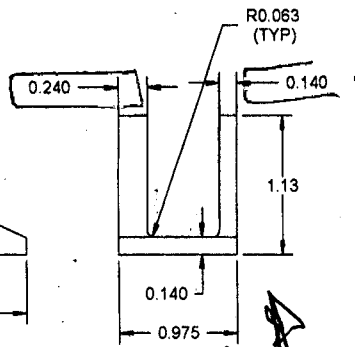
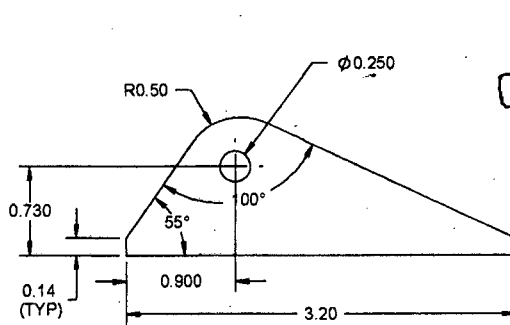
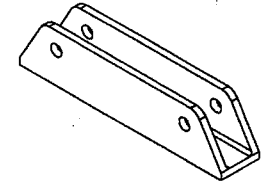
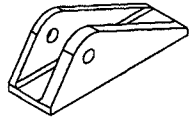
D212-725-1-111 LARGE ENGINE MOUNT

D212-725-1-109/-110/-111 NOTES:

- 1) MATERIAL: AISI 4140/4130 STEEL BAR PER MIL-S-5626/-6758 OR AMS 6382/6349/6529 OR AMS 6348/6370/6528 (REF. DART SPEC. M4140N-B OR M4130N-B) HEAT TREAT TO MIN. ULTIMATE TENSILE STRENGTH = 125 ksi
- 2) FINISH: PRIME & PAINT PER AIRCRAFT MAINTENANCE MANUAL
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

DESIGN JL	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DS	APPROVED	DRAWING NO. D212-725-1	REV. A SHEET 35 OF 36
DATE 06.11.20		TITLE 212S DETAIL PARTS	SCALE 1:1
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8 7 6 5 4 3 2 1



D212-725-1-109 SMALL ENGINE MOUNT
D212-725-1-110 OPPOSITE

D212-725-1-111 LARGE ENGINE MOUNT

*Terida,
Make sure that they made
the -110 (opposite to what's shown).
Before shipping. Thx. JPL*

D212-725-1-109/-110/-111 NOTES:

- 1) MATERIAL: AISI 4140/4130 STEEL BAR PER MIL-S-5626/-6758 OR AMS 6382/6349/6529 OR AMS 6348/6370/6528 (REF. DART SPEC. M4140N-B OR M4130N-B) HEAT TREAT TO MIN. ULTIMATE TENSILE STRENGTH = 125 ksi.
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CHECKED DS	APPROVED	DRAWING NO. D212-725-1	REV. A SHEET 35 OF 36
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